Work Ordo		103396		*10?	3396	*: }					Page 1
Item ID: Revision ID: Item Name:	D2932-2 206 Sadd	le Right side	,	Accept	*N9	೧೧೧4 ೧	1100	<u>)</u> *	Setup Sta	IV	S1* S2*
Start Date: Required Date: Reference:	6/24/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Custo	Item ID: omer:		•	- 01		
Approvals:	Process	s Plan: MUT	Date: \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\			Date:			Run Sta Sto	1/7	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Too	l ID Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr		Revision Nbr								,	'
D2932		Rev C		,. <u></u>		·—				·	
*100 *100* HAAS I		HAAS CNC VERTIC		0.00	`	Sf 13-08	-14	<u>le</u>	<u>ø_</u>		···
HAAS CNC vertice	ii machine #	number a inspect as	part number and batch number re programmed correctly.2-Ma s per dwg D2932 & attached D nd visually inspect as per	achine Step No 1 of Fol	io and visually						
*110 *110* Mill Conv		CQNVEHTIONAL M	IILLING MACHINE	0.00	OAS)	13/68/2-	2 .	6	_Ø	-	
Conventional Milli	ng Machine	Memo Machine	Keyway and inspect per attach								
*120 *120*		QC1- Inspect dimensi	ons to dimension sheet	0.00	SS	13-08-16		_ (e	Ø		
Quality Control		.vecino		-	\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \	13-08-14 13/08/22	٧,		J		

÷...

DQA:		_ Date:										TAPT
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / UPDA ⁻		ork Order up	odate only	AEROSPACE
Work Order					DISPOSITION			A	GAINST DE	PARTMENT	/PROCESS	
WORK Order	•				Rework	1		Skid-tube Cro	osstube	}	Water Jet	Engineering
Part No	,			ı	Scrap		1	—	nali Fab	Pro	d. Eng. Coor.	Quality
raitive	,				Use-as-is				inishing		e/Packaging	Other
NCR No	o				Suspected Unapproved		11,011	· —	mposite	ince/sto	Supplier	
Root	1			Desci	ription of work order update		Initial	Action		Sign &		<u> </u>
Cause	Date	Step	Qty		or non-conformance	1	nief Eng		า	Date	Verification	QC Inspector
Design		1 213	3.7			-				54.0	7 (11110)	<u> </u>
Doc/Data					•							
Equip/Tooling		1										
Handling/Pre												
Material										j		
Operator						-						
Offset/Setup												
Process												
Supplier						1						
Fraining												
Fransport												
Jnapproved												
			-			FA	ULT CA	TEGORY				
Landing	Gear	-			General '						·	
	Bending			- ·	Bend -		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	t 🗌	Temperature/Cure
	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualif	fied	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	tions Incomplete/Unclear	r 🗀	Part Moved		Wrong Stock Pulled
	Crushing				Countersink		Misalig	gned/off center		Positioned W	/rong	_
	Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/:	Surge	Other
	Inspectio	n Strip in	Tube		Drawing		Misread	b				
	Marks/Cl	natter			Drill Holes		Off-set					· · · · · · · · · · · · · · · · · · ·
	Turning S	equence			Finish AA		Out of	Calibration				
	Wave/Tw	ist in Tub	oe .		Fit/Function		Out of 9	Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Orde		3396				*10:	339	16*						Page
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D2932-2 206 Saddle R 6/24/13 7/12/13	ight side Start Qt Req'd Q	=		*6* *6*	Accept		1900 Cust Item I		100) * :	Setup Sta	1	IS1* IS2*
Approvals:	Process Pla			_		- -			ite:		!	Run Sta Sta	``]\ nn	JR1* JR2*
Sequence ID/ Work Center II 130 *130* QC Quality Control	D	Operatio Descripti QC8- Inspe		nd check		Set Up/ Run Hours 0.00	B. 2	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Numbe	
*140 *140* HandFinish Hand Finishing		Chemical C	Conversion Co	at per QSI0	05 4.1	0.00					6	26	B 13°	8.26
150 *150* Powdercoat Powder Coating		White Glos	S(Ref:4.3.5.1) Memo START TIM		11-5	0.00 0.00 OVEN TEMPERATUR	RE:			4	XX	M	J13	12/6

M126125

DQA:		_ Date:			•			_				TOART
QA Closed:		Date:			WORK ORDER NON	-CC	ONFO	RMANCE / U		Work Order i	update only	AEROSPACE
					DISPOSITION					DEPARTMEN	, ,	
Work Orde	er:				n ayyark	ı		ا مارید اینان	C	\neg	Water Jet	- Carinanian
Part N	lo				Rework Scrap			Skid-tube Machining	Crosstube Small Fab		od. Eng. Coor.	Engineering Quality
1 41 (1)					Use-as-is			noforming	Finishing		ore/Packaging	Other
NCR N	lo				Suspected Unapproved		,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	Large Fab	Composite		Supplier	
Root				Desc	ription of work order update		nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Design		T										
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material	<u> </u>											
Operator 1												
Offset/Setup												
Process	_	-										
Supplier	_											
Training	_											
Transport												
Unapproved												
						FAI	ULT CAT	EGORY				
Landir r	ng Gear			_	General		1		_	_	-	-
}	Bending			 	Bend	<u> </u>		rogram		Outside Di	-	Pressure/Forced
}		ot Concer	ntric	_	BOM/Route	igspace	Grain				r tolerance	Set-up
	Cracks			_	Broken/Damage/Defect	ļ	Hardwa		_	Part Incorr	-	Temperature/Cure
	— i	nk/Ripple	/Wave		Burrs	$ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{ld}}}}}}$	1	on Incomplete/Ur	·	Part Lost/N	· ·	Weld
}	Cuffs				Contamination	<u> </u>	1	ions Incomplete/U	Jnclear	Part Move		Wrong Stock Pulled
}	Crushing			\vdash	Countersink	igspace	1	ned/off center	-	Positioned		¬
}	Heat Tre			<u> </u>	Cut Too Short		Mislabe		L	Power Loss	/Surge	Other
}		n Strip in	Tube	<u> </u>	Drawing	\vdash	Misread	I				
	Marks/Cl				Drill Holes	\vdash	Off-set					
}	─	Sequence		<u> </u>	Finish		1	alibration				
	[Wave/Tv	vist in Tub	e		Fit/Function		Out of S	equence				·

Work Orde		3396		*103	3396*				_		Page 3
Item ID: Revision ID: Item Name: Start Date: Required Date:	D2932-2 206 Saddle Ri 6/24/13	ight side Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*	Accept	*N900 Cust Item I Customer:		100)* s	etup Star Stop	171	S1* S2*
Reference: Approvals:		an:	Date:	Tooling: SPC (Y/N):		nte:	-	R	tun Star Stop	. "I V I	R1* R2*
Sequence ID/ Work Center I 160 *160* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo) <u></u>	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp OA Q5 13.08.27
170 *170* Packaging Packaging		Identify as per dwg & Sto	ck Location:	BF 0.00 0.00				_6x-			B-8-27.
180 *180* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00						3/8/2	29 (1)
									gl (3-08.	-28

DQA:		– Date:				_						TAART
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / U		Vork Order up	odate only	AEROSPACE
Work Orde	r				DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Part N					Rework Scrap]		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo	_			Use-as-is Suspected Unapproved			noforming Large Fab	Finishing Composite		re/Packaging Supplier	Other
Root		Τ		Desc	ription of work order update		Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	1	nief Eng	1	ription	Date	Verification	QC Inspector
Design		 				<u> </u>			· <u>'</u>			
Doc/Data												
Equip/Tooling												
Handling/Pre				1								
Material ् 🗝 🎝	(c											
Operator	¥]									
Offset/Setup												
Process	7	1										
Supplier												
Training												
Fransport										-		
- bevorqqsnL												` <u>`</u> .
		· · · · · ·				FA	ULT CAT	EGORY		<u>.</u>		
Landin	g Gear				General		•					
	Bending				Bend		Folio/P	rogram	Γ	Outside Dim	ensions	Pressure/Forced
Ī	Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	:t T	Temperature/Cure
	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Ur	ngualified	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/U	Jnclear	Part Moved	Ť	Wrong Stock Pulled
ſ	Crushing			T	Countersink		-	ned/off center		Positioned V	∟ Vrong	
Ī	Heat Tre	at			Cut Too Short		Mislabe			Power Loss/		Other
ľ	Inspection	n Strip in	Tube		Drawing		Misread		_	·	·	<u> </u>
	Marks/C	•			Drill Holes		Off-set				<u> </u>	
ļ	Turning :	Sequence			Finish		1	Calibration				
		vist in Tub		_	Fit/Function		4	equence				

Picklist Print

June-24-13 1:54:42 PM

Work Order ID:

103396

Parent Item:

D2932-2

Parent Item Name:

206 Saddle Right side

Comments:

IPP: B00.06.26New DWG rev (mpp 2069)EC IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 Saddle Billet, 7075		Manufactured	No			100	Each	48.0000	16	31	13-08-	15	
				Location		Loc Qty	Lo	oc Çode					
				MAT042		2							
				. 9841	7	2			2	<u>-</u>			
	Madais	\mathcal{A}		MAT045		46							
	Maience			9756	53	46	ı						
	Materio Not Pulle 0			97	191					4_			

Page 1

Required Date: 7/12/13

Required Qty: 6.00

Start Date: 6/24/13

Start Qty: 6.00

DQA:			Date:			<u>-</u>							``ΔRT
QA Closed:			Date:			WORK ORDER NON	-CC	DNFO	RMANCE / UPD		ork Order u	odate only	AEROSPACE
						DISPOSITION				AGAINST DE	•		
Work Orde	er: -					l	,		a		7		-
Doet 1	u o					Rework			— —	Crosstube		Water Jet	Engineering
Part N	۱O					Scrap Use-as-is			Machining noforming	Small Fab Finishing	-1	d. Eng. Coor. re/Packaging	Quality Other
NCR N	No.					Suspected Unapproved		HIEH	~ 	Composite	NEC/3to	Supplier	
	_						j j		an Bo / on		J	oappne, _	
Root					Desc	ription of work order update	1	nitial	Action	n .	Sign &		
Cause		Date	Step	Qty	, ,	or non-conformance	Ch	ief _, Eng	Descript	tion	Date	Verification	QC Inspector
Design						•							
Doc/Data													
Equip/Tooling	Щ												
Handling/Pre	Ц						_		1				
Material	Ш												
Operator					7							• •	
Offset/Setup					-				1				
Process													
Supplier													
Training	Ш												
Transport	Ш			-	ļ								
Unapproved				<u> </u>									
		<u>.</u>					FAL	JLT CAT	TEGORY				
Landii	ng G	ear			r	General	_				-	_	
	\Box	Bending				Bend	Ш	Folio/P	rogram 'rogram'	<u></u>	Outside Dim	ensions	Pressure/Forced
			ot Concer	ntric		BOM/Route	Ш	Grain		<u> </u>	Over/Under	tolerance	Set-up
	-	Ċracks				Broken/Damage/Defect	Щ	Hardwa	re		Part Incorred	ct	Temperature/Cure
	$\overline{}$		nk/Ripple,	/Wave		Burrs	Ц	Inspect	ion Incomplete/Unqu	alified	Part Lost/Mi	ssing	Weld
	\vdash	Cuffs			ļ	Contamination	Ш	instruct	ions Incomplete/Unc	lear	Part Moved		Wrong Stock Pulled
	\vdash	Crushing				Countersink	-	-	ned/off center		Positioned V		_
	\vdash	Heat Trea				Cut Too Short	Ш	Mislabe	eled		Power Loss/	Surge	Other
	\vdash		n Strip in	Tube		Drawing	\vdash	Misread	d				
		Marks/Ch				Drill Holes		Off-set					
		Turning S	equence			Finish		Out of (Calibration				
	l l	Wave/Tu	ist in Tub	P		Fit/Function	1 1	Out of 9	Seguence				

DART AEROSPACE LTD	Work Order:	103396
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C	· ·	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

		•		Re	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		0120	. 112	120	6120		
В	0.100	0.140		6113	1114	.120	0121		
C	0.100	0.140		-121	109	0114	0119		
D	0.210	0.230		.274	.225	.227	:227	Ì	
E	1.245	1.255		1.248	1.249	1.249	1.244		
F	1.245	1.255		1248	1.249	1.249	1.244		
G	2.495	2.505		2497	2.498	2.497	2.497		
Н	0.510	0.515		,512	- 512	451Z	,5/2		
ı	1.572	1.582		1.574	1.577	1.575	1.5765		
J	2.495	2.505		2.497	2.498	2.496	2.496		
К	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		. 314	.314	.314	.314		
M	0.235	0.240		.238		· 238	-238		
N	0.100	0.140		,108	.238 .123	.123	6124		*** ,
0	0.540	0.560		.546	.551	.551	.544		
Р	0.490	0.510		.500	.551 .498	.444	-501		
Q	3.715	3.725		3.717	3.717	2.719	3.718		
R	2.470	2.510		2.490	2.488	2.490	7.488		
S	0.240	0.270		.258	. 245	0760	261		
Т	0.100	0.180		0125	e135	, i 35°	.135		
Ü	1.625	1.635		1.629	1.630	1.628	1.628		
V	1.362	1.372	-	1.366	1.367	1,346	367		
٧٧	0.316	0.321		6316	,316	.316	.3//-		,
X	1.125	1.145	• • •	1.131	1.145	1.131	1.1318		
Υ	1.565	1.585		1.5715	1.585	_1.57/_	1.57/7		
Z	0.178	0.198		188	4188	188	.188		
AA							V - V - V - V - V - V - V - V - V - V -		-
AB						-			
AC							i		
AD									
ΑE		_			,				
AF							•		
AG			· · · · · · · · · · · · · · · · · · ·		, i	-	_	_	
AΗ									
	Acc	ept/Reje	ct	SAS					

	ol	ΔΔ		•		
Measured by:	M	9-80	. Audited by	40	0.0	
Date:	13-08-16	13/08/27	Date:	13 08/22	δg	

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	1
[C	07.03.21	Revised per drawing revision C	KJ/JLM	Cidl

		•	•
			•
		·	
		• ,	
			. 1
		·	
	•		
•			
		• •	
•			
• •			

DART AEROSPACE LTD	Work Order:	103396
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

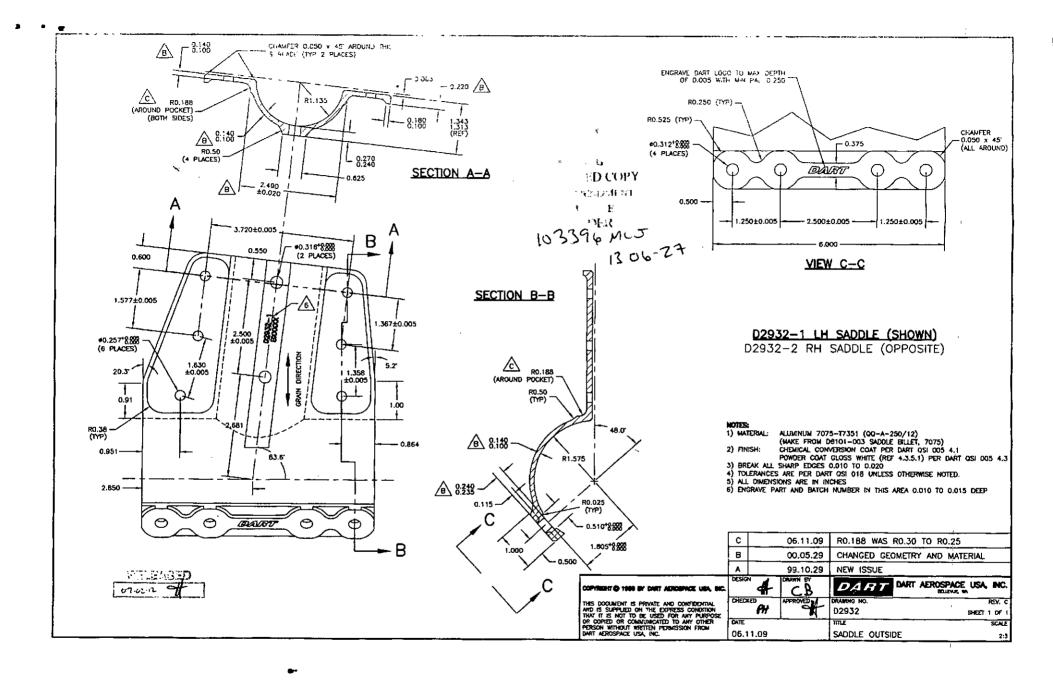
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

• •	 -			Re					
Dim	Min	Max	Go/No Go Gauge	50	6 de	ą	42	Ву	Date
Α	0.100	0.140		-118	.115				
В	0.100	0.140		120	.117				
С	0.100	0.140		120	117		<u> </u>		
D	0.210	0.230		227	1227				
E	1.245	1.255		1.249	1.249				
F	1.245	1.255		1.249	1.244				
G	2.495	2.505		2.497	2.447			T	
Н	0.510	0.515		。かに	-512				
L	1.572	1.582		1.576	1.576				
_ J	2.495	2.505		2 497	2.498	<u>.</u>	1		
K	0.257	0.262		.259	.259				
_l _	0.312	0.317		.314	. 314				
M	0.235	0.240		- 233	.238				
N	0.100	0.140		.123	0122				
_0	0.540	0.560		.545	.547				
Р	0.490	0.510		.497	,500				
Q	3.715	3.725		3.717	2.717	···· ·			
R	2.470	2.510		2,490	2.490			1 1	·
S	0.240	0.270		.260	,240				
T	0.100	0.180	,	135	.135			<u> </u>	<u>-</u>
U	1.625	1.635		1629	1.627				
~~~	1.362	1.372	•	1.365	1.365				
W	0.316	0.321		.316.	,310				
X	1.125	1.145		1.131	1.131		,		
Υ	1.565	1.585	••	1.5717	1.570			i	
Ζ	0.178	0.198		188	.188				
AA					1	_		"	,
AB						,		].	
AC								1	
AD									
AE			_						
AF							-		<del> </del>
AG									
АН						_		1	
	Acc	ept/Reje	ct						

	01	$\mathcal{V}$			^ ^ =
Measured by:	AA	44	Audited by	13. A	VV
Date:	13-08-16	13/08/22	Date:	13/08/22	) OB

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	1
С	07.03.21	Revised per drawing revision C	KJ/JLM A	Cidl

		· ~		
•				
•				
• • •	·			



,							
•	•						
	٠.						
					➡		
		*				,	
				٠			
•					·		
				. •	,		
					t f		
			\$ }				
		;	<b>2</b> .				
				. *		-	
•							